

■ Series 5102 • AluSurf

		For Side Milling (A) and Slotting (B)			uncoated			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.									
Material Group	A		B	Cutting Speed – vc m/min			D1 – Diameter										
	ap	ae	ap	min		max	mm	1,5	2,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,014	0,018	0,036	0,054	0,072	0,090	0,108	0,144	0,180
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,012	0,016	0,032	0,049	0,065	0,081	0,097	0,130	0,162

NOTE: Multiply ap for milling machine spindle with ceramic bearings by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.

Application Data • Series 5103 • AluSurf™

■ Series 5103 • AluSurf

		For Side Milling (A) and Slotting (B)			uncoated			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.									
Material Group	A		B	Cutting Speed – vc m/min			D1 – Diameter										
	ap	ae	ap	min		max	mm	3,0	6,0	8,0	10,0	12,0	16,0	20,0			
N	1	1,5 x D	0,5 x D	1 x D	500	–	2000	fz	0,027	0,054	0,072	0,090	0,108	0,144	0,180		
	2	1,5 x D	0,5 x D	1 x D	500	–	1500	fz	0,024	0,049	0,065	0,081	0,097	0,130	0,162		

NOTE: Multiply ap for milling machine spindle with ceramic bearings by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.

Application Data • Series 51N3 • AluSurf™

■ Series 51N3 • AluSurf

		For Side Milling (A) and Slotting (B)			uncoated			Recommended feed per tooth (fz = mm/th) for side milling (A). For slotting (B), reduce fz by 20%.									
Material Group	A		B	Cutting Speed – vc m/min			D1 – Diameter										
	ap	ae	ap	min		max	mm	6,0	8,0	10,0	12,0	16,0	20,0				
N	1	1 x D	0,5 x D	1 x D	500	–	2000	fz	0,060	0,080	0,100	0,120	0,160	0,200			
	2	1 x D	0,5 x D	1 x D	500	–	1500	fz	0,054	0,072	0,090	0,108	0,144	0,180			

NOTE: Multiply ap for milling machine spindle with ceramic bearings by 0,5.
For better surface finish, reduce feed per tooth.
Above parameters are based on ideal conditions. For smaller taper machining centres, please adjust parameters accordingly on diameters >12mm.